

Work Order ID 63150

Thursday, October 21, 2010 3:53:24 PM

Page 1

Item ID: D205-633-017

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010 Start Qty: 2.00

Cust Item ID:

Required Date: 10/28/2010 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: 10/10/22

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D205-633

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D205-633-017 CHG001

*S 10/11/10**HJ for BG 10-11-04*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Rec'd 11/14 (2)

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*S 10/11/10**(42)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D205-633-017

Accept

Revision ID:

Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010 Start Qty: 2.00

Required Date: 10/28/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-633-017

Location:

PPP Rev: B

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/11/18 *(2)*

10/11/18 *MF*

10-18-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 63150

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A□04.05.10□New Issue□KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-14A		Purchased	No			110	Each	187.0000	1	2			
---------	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--



Bolt

Location

Loc Qty

Loc Code

ST357

171

114752

1

115371

70

115936

100

ST358

16

113359

16

AN4-5A

Purchased

No

110

Each

276.0000

2

4



Bolt

Location

Loc Qty

Loc Code

ST356

276

115016

100

115767

76

115936

100

AN4-6A

Purchased

No

110

Each

1,026.000

2

4



Bolt

Location

Loc Qty

Loc Code

ST356

1026

112933

96

113149

17

115108

213

115457

500

115936

200

M115936

M115767

M115108

10/11/4 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 63150

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

AN4-7A
Bolt

Purchased No

110 Each

167.0000

2

14

Location

Loc Qty

Loc Code

ST356

167

113226

117

115373

50

M113226

AN5-14A
Bolt

Purchased No

110 Each

141.0000

1

2

Location

Loc Qty

Loc Code

ST337

134

115429

26

ST338

7

112489

7

AN5-6A
Bolt

Purchased No

110 Each

24.0000

1

2

Location

Loc Qty

Loc Code

ST337

24

112243

24

AN960ID416
Washer

NAS1149D0463J Purchased

No

110 Each

24.0000

15

30

Location

Loc Qty

Loc Code

ST300

24

113288

24

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

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Work Order ID: 63150

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

~~AN960D516~~ NAS1149D0563J Purchased No

110 Each

34.0000

4

8



Washer



1114742

[Signature]

Location

Loc Qty

Loc Code

ST

34

103694

18

107534

12

109287

4

D2021-101

Manufactured No

110

Each

13.0000

1

2



Eyebolt



[Signature]

Location

Loc Qty

Loc Code

ST005

13

59808

13

D2022-101

Manufactured No

110

Each

61.0000

2

4



Spacer



59808

[Signature]

Location

Loc Qty

Loc Code

ST504

61

50746

23

52325

10

61990

28

D2022-103

Manufactured No

110

Each

74.0000

2

4



Spacer



61990

[Signature]

Location

Loc Qty

Loc Code

ST004

74

47964

74

47964

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Page 3

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 63150

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2562-007

Manufactured No

110 Each

2.0000

1

2



Strut

Location

Loc Qty

Loc Code

ST264

2

58620

2

110 Each

0.0000

1

2

D2563

Manufactured No



Step Weldment Assembly

D2565-401

Manufactured No

110 Each

1.0000

1

2



Strut

Location

Loc Qty

Loc Code

ST259

1

58621

1

110 Each

1.0000

1

2

D2565-403

Manufactured No



Strut

Location

Loc Qty

Loc Code

ST259

1

58622

1

110 Each

1.0000

1

2

D2565-405

Manufactured No



Strut

Location

Loc Qty

Loc Code

ST259

1

58623

1



58620



63121



62784 1x



58621 1x



62786 1x

58623 1x

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 63150

Parent Item: D205-633-017

Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

D2565-407

Manufactured No

110 Each

1.0000

1

2

SxZ
Strut

Location

Loc Qty

Loc Code

ST259

1

58624

1

17.0000

1

58624 1p

D2565-409

Manufactured No

110 Each

17.0000

1

CxZ
Strut

Location

Loc Qty

Loc Code

ST259

17

47831

9

47899

8

1.0000

1

47899

D2565-411

Manufactured No

110 Each

1.0000

1

2

SxZ
Strut

Location

Loc Qty

Loc Code

ST259

1

58625

1

3,253.000

8

58625 1p

MS21042L4

Purchased No

110 Each

3,253.000

8

16

SxZ
Strut

Location

Loc Qty

Loc Code

ST300

3253

113422

68

114523

8

114718

16

114784

32

115108

129

115589

1900

115621

1100

115589

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 63150



Parent Item: D205-633-017



Parent Item Name: Heli-Access-Step, Standard Low Gear

Start Date: 10/21/2010

Required Date: 10/28/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

830.0000

2

4



8
Nut

Le 10/24/10 (2)

Location

Loc Qty

Loc Code

ST139

26

114813

26

ST300

804

115156

304

115594

500

11/5/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	4	4	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: B

Date: 07.08.21